Work Order ID 70148-Page 1 Monday, May 30, 2011 11:23:39 AM D3197-041 Item ID: Accept Setup Start Revision ID: Stop Item Name: Bar Assembly Start Date: 5/30/2011 Start Qty: Cust Item 1D: Required Date: 6/10/2011 Req'd Qty: 1.06 Customer: Reference: Run Start Date: 1-05-3 Chooling: Approvals: Process Plan: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Reject Set Up/ Tool # Plan Accept Insp. Work Center ID Description Qty Run Hours Stamp Code Number Draw Nbr Revision Nbr D3197 Rev B 100 0.00 BAND SAW Bandsaw 0.00 Mema Jeaspa Bandyaw Cut blanks: 29.125" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS I 0.00 Memo HAAS CNC vertical machine #1 1-Face ends to lenght per dwg D3197. 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr 120 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control

DATE         STEP         PROCEDURE CHANGE         By         Date         Qty         Approval Chief Eng / Prod Mgr         Approval OC Inspector           Part No:	W/O:		*****	WO	RK ORDER CHANGE	ES			85 45 45 A
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date:	DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Chief Eng /	Approval OC Inspector
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NCR: WORK ORDER NON-CONFORMANCE (NCR)	Resolution:								
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DATE STEP Description of NC Section A Section A Section A Section C Section	DATE			Action Description Chief Eng				QC Inspector	
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Item ID:

D3197-041

Revision ID:

Item Name:

Bar Assembly

Start Date:

5/30/2011

Start Oty: 4.00 Required Date: 6/10/2011 Req'd Qty: 4.00

Accept



Setup Start



Stop

Reference:

Approvals:

Sequence ID/

Work Center ID

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Cust Item ID:

Customer:

Start Run

Stop



QC:

Operation Description

Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

Set Up/ Run Hours

0.00

Tool ID

Tool# Plan Code

Reject Accept Qty Qty

Reject Number Stamp

Insp.

140

130

OC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

2/11/04/02

150

HardFinish

Chemical Conversion Coat per QS1005 4.1

0.00

0.00

6 \$ Il ulo 6/62

Hand Finishing

Memo

W/O:			WO	DE ODDED CHANCE					
TO SAMELAYA	1		VVO	RK ORDER CHANGE	-3	15.0		Approval	Autouvet
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Chief Eng / Prod Mgr	Approval OC inspector
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		Description of NG		Corrective Action Section	veru			Approval	Approval
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#### Work Order ID 70148

Monday, May 30, 2011 11:23:39 AM

Item ID:

D3197-041

Revision ID:

Item Name:

Bar Assembly

Start Date:

Required Date: 6/10/2011

5/30/2011

Start Oty: 4.00

Reg'd Oty: 4.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Tool 1D

Reference:

Approvals:

Process Plan:

OC:

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool #

Plan

Code

Accept

Oty

Start Rain

Reject

Oty

Number Stamp

Stop

Insp.

Sequence ID/ Work Center 1D

160

Powdercoat

Powder Coating

Quality Control

Operation

Grey Sandtex(Ref:4.3 5 6) per OS1005 4 3

Description

Memo

0.00

0.00

OVEN TEMPERATURE.

OC3- Inspect Part Finish

0.00

Memo

0.00

180

Small Fab Small Fab

Small Fab

Memo

Assemble D3197-041 as per Dwg D3197

6 \$ Hu-6-2

Reject

0.00

0.00

W/O:			WO	RK ORDER CHANG	ES			-	
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
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DATE	STEP Description of NC Section A		Initial Action Descript Chief Eng Chief Eng		n Sign & S		Section C	Chief Eng	QC Inspector
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#### **Picklist Print**

Monday, May 30, 2011 11:23:36 AM

Work Order ID: 70148

Parent Item:

D3197-041

Parent Item Name: Bar Assembly



Start Date: 5/30/2011

Start Qty: 4.00

Required Date: 6/10/2011

Required Qty: 4.00

Comments	:
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IPP Rev: A New Issue 05-11-08 JLM IPP Rev:B As per Rev B 06-03-10 JLM

	Replacement Item 1D	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	NAS1149D0363J	Purchased MII6583	No.	(DP)		180	Each	0 0000	6	24	11/06	100	?
D2690-5  Lanyard Assembly	I	Manufactured	No	0.0000		180	Each	11.0000		89	511/0	06/0	Ĺ
				Location		Loc	Dry	Loc Code	2		1		
				ST020			11			-			
					66820		!!			2 4	7		
D3242-1	i	Manufactured	No			180	Each	4 9900		93	4/0	6/0	2
				Location		1.00	ity	Loc ( ode	1		, A		
				\$1044			4			21			
					65390		4		_	8 4			
D3489-3-200 PIP PIN		Manufactured	No			180	Cach	9 0000	2	\$	11/0	06/0	2
				Location.		Loc C	oty	Loc Code	6				
				GA			9			1	6		
					68563		9			62 4	1		

Dail Ac	rospace Li	id								
W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #:	100	ory:						
	Resc	olution:	Disposition	:	QA: N/C CI	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	()				
		Corrective Action			n Section 8 Verification			Approval	Approval	
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector		
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Monday, May 30, 2011 11:23:36 AM

Work Order ID: 70148

Parent Item:

D3197-041

Parent Item Name: Bar Assen:bly

M7075T73R1.000

Purchased

Purchased

Purchased

7075-T73 Rd Bar 1.00

MS21042L3

Nut

Start Date: 5/30/2011

Start Qty: 4.00

30 8650

Required Date: 6/10/2011

Required Qty: 4.00

2.42

Location	<u>L.</u>	e Qiy	Loc Code
MAT012		30.865	
115165		27	
116405		4 54	
116604		2.25	
116835 *		12	
116962 x 2	9.375		
	180	Cach	2.119.000

180

No

No

No

2,119.000

Location Loc Oty Loc Code ST300 2119 116391 11 116540 142 116549 766 117441 800 117601 400 100 122,0000 Lach

Location. Loc QIV Loc Code ST292 122 100151 122

Screw

MS27039-1-24

1/48/100 1906 96 840 1907 BOOL WILL BOOK 144 896/F BOOK BOOK 144

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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval OC Inspector
Part No	• 1	PAR #:	Fault Cated	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
Resolution:			Disposition	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	1)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval
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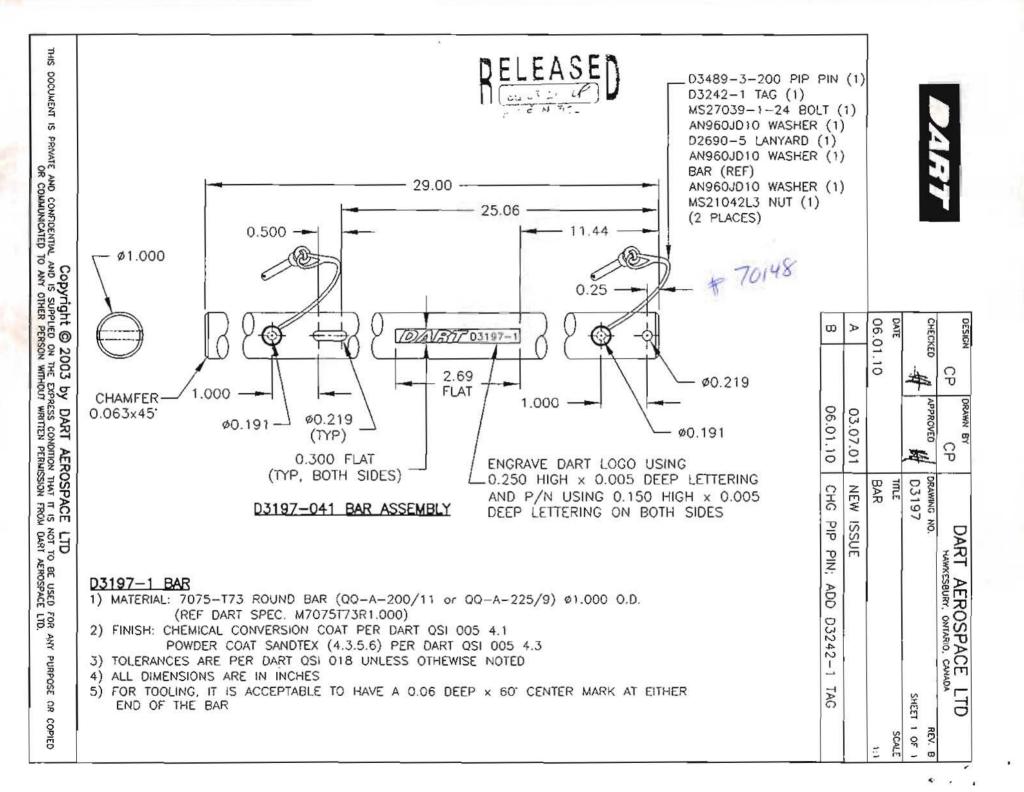
DART AEROSPACE LTD	Work Order: 7	5148
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197 Rev: 8		Page 1 of 1

nspection Dwg	: D3197 Rev	1:8				Pag	ge 1 of 1
		T ARTICLE II	_	_	ECKLIST otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		iments
29.00	+/-0.030	19-00	/		instape		
25.06	+/-0.030	25.06	-		14		
11.44	+/-0.030	11.436	/		Vern CNC-0	2	
0.500	+/-0.010	499	/		Vern 1-3		
0.250	+/-0.030	245			**		
Ø0.219	+0.005/-0.000	.219	/		^		
Ø0.191	+0.005/-0.000	.192	1		-		
1.000	+/-0.005	1.000	/				
2.69	+/-0.030	2689			361		
1,000	+/-0.010	1.000			-		
0.300	+/-0.010	.305	/		-		
0.063 x 45°	+/-0.010	.06×45°	/		- 18		
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easured by:	11/06/02	Audited by:		2	Prototype	Approval:	N/A N/A
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A 04.04.20	New Issue	(P/O D3197	7-041)			KJ/JLM	Approved

	Date.	11106100	Date: 11/06/02	Date:	N/A
Rev	Date	Change		Revised by	Approved
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W/O:		WORK ORDER CHANGES									
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